

Date: Tuesday, 09/10/2007 2:55:09 PM  
 User: Linda Lacelle

## Process Sheet

Split #3

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : ARM

Job Number : 35029-3

Estimate Number : 12578

P.O. Number : N/A

This Issue : 09/10/2007

S.O. No. : N/A

Part Number : D3560041

Prsht Rev. : NC

Drawing Number : D3560 REV C

First Issue : N/A

Type : SMALL / MED FAB

Project Number : N/A

Previous Run : 35029

Drawing Revision : C

Material : N/A

Written By :

Due Date : 19/10/2007

Qty: 10 Um: Each

Checked &amp; Approved By :

Comment :

Est Rev: A New Issue 07.05.24 EC  
 est rev B ECN 987 07.10.09 EC verified by: DD

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B0500X05000

6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.4648 f(s)/Unit Total : 14.6475 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: W105950

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks 16.750" long

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA693 Rev: AA &amp; Dwg D3560 Rev: C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE





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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35029

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL

07/10/28

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

PLATE

3 34478

07-11-07

5

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

PTC

→

1-Weld assembly as per dwg D3560

### STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad )
- 2- set up bracket and arm on jig
- 3- preheat bracket and arm with torch
- 4- clean before welding with brush
- 5- set up machine to 135 amps
- 6- weld across bottom and top ends
- 7- reheat with torch ( )
- 8- on one side weld from bottom to top half way
- 9- same for other side (half way)
- 10- from half way point weld the rest of the first side (ease off pedal near end)
- 11- same for remaining side (ease off pedal near end)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/28

5

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-11-07

07.11.07	7.0	split w/o for 5 on this w/o <del>and from 2<sup>nd</sup> split</del>	Qty 3 left from original / 2 07.11.07
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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ML 07-11-12 (X5)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 07-11-12 (5)

12.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Spacer

batch: B35330

MF 07-11-14

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

MF 07-11-14 (5)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-11-14 (5)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST124

AS 07/11/14

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(5) 07/11/15

Job Completion



u 07-11-15

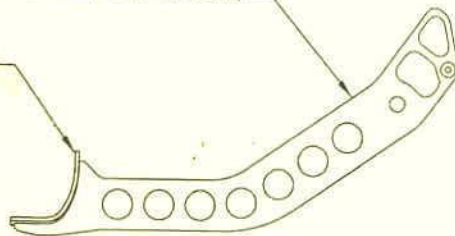






D3560-1 ARM (-041, SHOWN)  
OR D3560-2 ARM (-042, OPPOSITE)

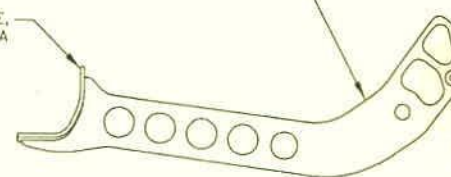
D3592-1 PLATE,  
SEE DETAIL A



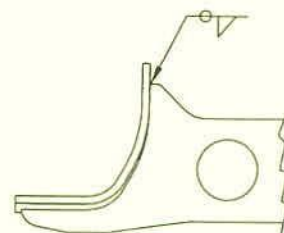
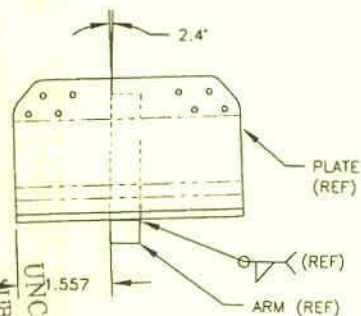
D3560-041 ARM WELDMENT (SHOWN),  
D3560-042 ARM WELDMENT (OPPOSITE)

D3560-3 ARM (-043, SHOWN)  
OR D3560-4 ARM (-044, OPPOSITE)

D3592-1 PLATE,  
SEE DETAIL A



D3560-043 ARM WELDMENT (SHOWN),  
D3560-044 ARM WELDMENT (OPPOSITE)



**DETAIL A**  
(SCALE 1:1)

**GENERAL NOTES**

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
07.06.19

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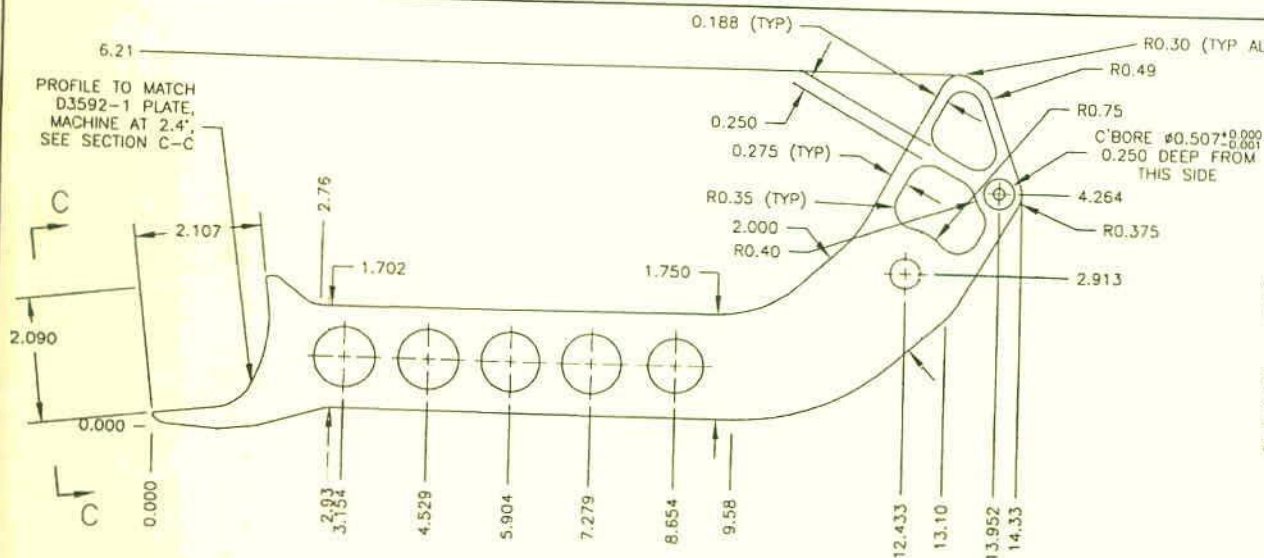
C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD. HAMPSHIRE, OXFORD, CANADA
CHECKED	APPROVED	DRAWING NO. D3560
DATE	TITLE	SCALE
07.06.19	ARM WELDMENT	1:4

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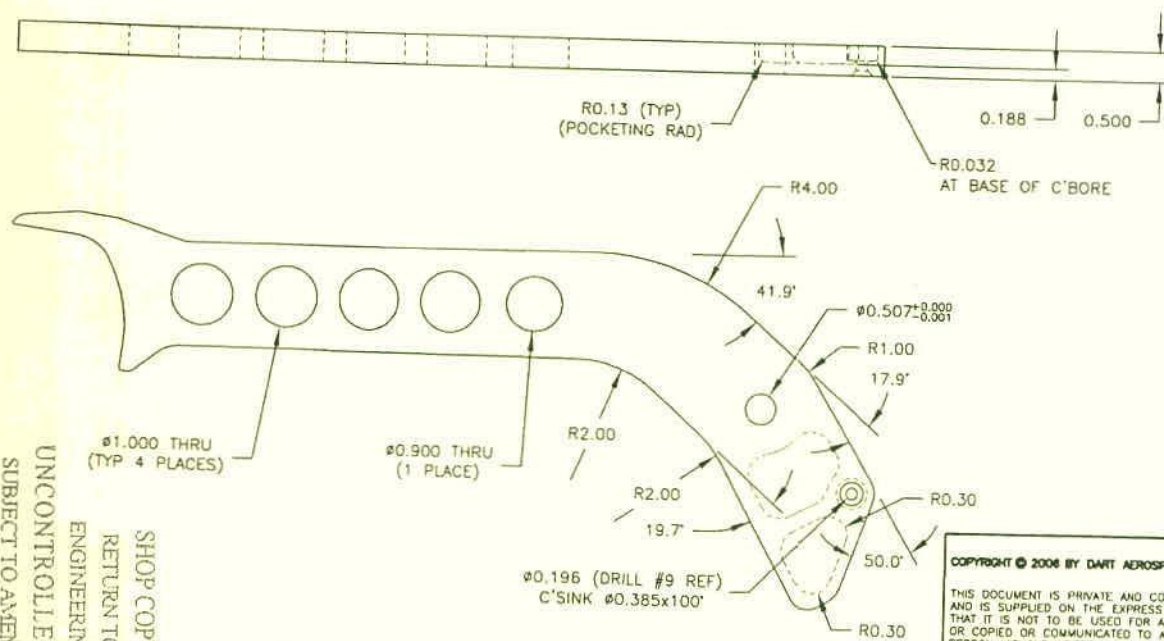




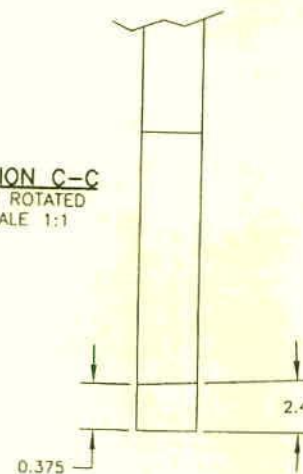


**D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)**

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



**SECTION C-C**  
VIEW ROTATED  
SCALE 1:1



**RELEASED**  
07.06.19

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DATE	07.06.19	TITLE	ARM WELDMENT		
					REV. C SHEET 3 OF 3 SCALE 1:2

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